



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA25A-3
Job Sheet 173450



Part No: SWA25A-3

Job Qty: 1 ea

Part Name: Electric Swivel 25,000 lb Safe Work Load (11,340 Kg)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA25A Rev 1 IPP Rev A 18.02.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/15/18	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	1 pcs		3/16/18	0.00	2.00	Small Fab-9		JB AP
120	QC	1 pcs		3/16/18	0.00	0.00	QC5		MD
125	DC	1 pcs		3/16/18	0.00	0.00	DC		
130	Packaging	1 pcs		3/16/18	0.00	0.00	Packaging3		smf
140	QC21-FG	1 Ea		3/16/18	0.00	0.00	QC21		21

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA25A swivel manual Engrave
Descriptions: T/N And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.
125 - Photocopy blue file OM & OOPM-SWA25A Rev2
130 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-5/8	Set Screw	1 Ea (1 ea)	90-Start up Operation	5037083
188-FSCS-1032-5/8	Wire Clamp Screw	4 Ea (4 ea)	110-Small Fab	5027240
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	5031223
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5031224
EL314-SJTOW	3 Wire	6 ft (6 ea)	110-Small Fab	547767
SWA10A-1100	Upper DU Bearing	1 Ea (1 ea)	110-Small Fab	5029387
SWA10A-1200	Lower DU Bearing	1 Ea (1 ea)	110-Small Fab	5036190
SWA10A-1300	Roller Thrust Bearing	1 Ea (1 ea)	110-Small Fab	5036727
SWA10A-1400	Circlip	1 Ea (1 ea)	110-Small Fab	5036191
SWA10A-1800	Cover	1 Ea (1 ea)	110-Small Fab	5031913
SWA10A-300	Bearing Housing	1 Ea (1 ea)	110-Small Fab	5034293
SWA10A-400	Thrust Washer	1 Ea (1 ea)	110-Small Fab	5049928
SWA10A-500	Semi-Rings	1 Ea (1 ea)	110-Small Fab	5029393
SWA10A-600	Collar	1 Ea (1 ea)	110-Small Fab	50293519
SWA10A-700	Wire Clamp	2 Ea (2 ea)	110-Small Fab	5017557
SWA25A-100	Lower End	1 Ea (1 ea)	110-Small Fab	5029395
SWA25A-200	Upper End Swivel	1 Ea (1 ea)	110-Small Fab	5029396
SWA6A-1900	Female Spade Terminal - 1/4"	6 Ea (6 ea)	110-Small Fab	5031234
SWA6A-800B	Connector Bushing	1 Ea (1 ea)	110-Small Fab	5029420
SWA6A-900B	Rotary Contact	1 (1 ea)	110-Small Fab	5049653

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-5/8	1	198	0
	188-FSCS-1032-5/8	4	176	0
110-Small Fab	EL-PLUG-F	1	38	0
	EL-PLUG-M	1	35	0
	EL314-SJTOW	6	1	0
	SWA10A-1100	1	5	0
	SWA10A-1200	1	9	0
	SWA10A-1300	1	14	0
	SWA10A-1400	1	9	0
	SWA10A-1800	1	14	0
	SWA10A-300	1	14	0
	SWA10A-400	1	0	0
	SWA10A-500	1	0	0
	SWA10A-600	1	16	0
	SWA10A-700	2	32	0
	SWA25A-100	1	0	0
	SWA25A-200	1	0	0
	SWA6A-1900	6	64	0
	SWA6A-800B	1	0	0
	SWA6A-900B	1	0	0

Part Spec

DART
AEROSPACE

Container No: S047209

Part: SWA25A-3

Job No: 173450

Serial No/Batch: S047209

Revision: 1

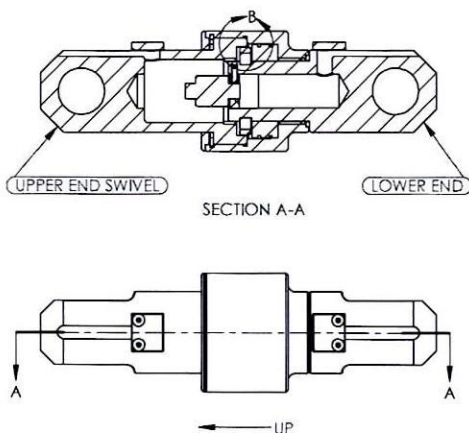
Inspector:

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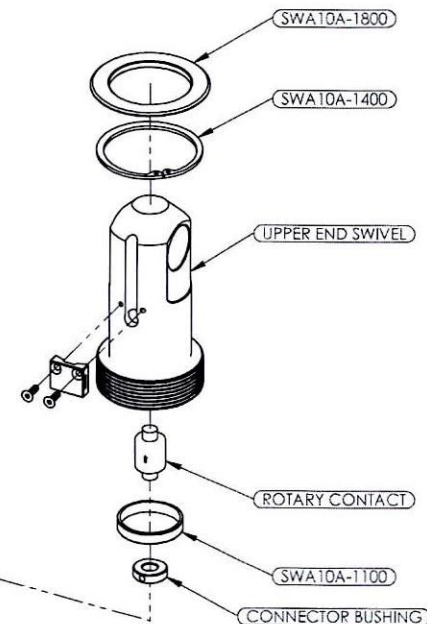
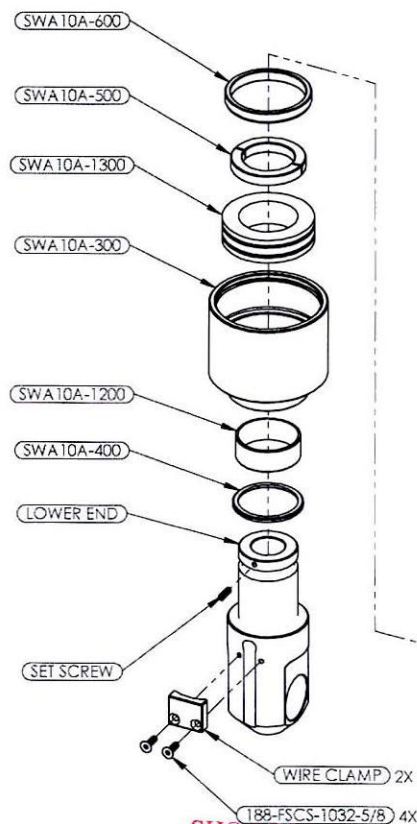
Date: 03/02/18

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DETAIL B
SCALE 1:1



-2/QTY	-3/QTY	-4/QTY	-5/QTY	-6/QTY	B/O	Part #	Description	Material	B/O INFORMATION OR SPECIFICATIONS
1	1	1	-	-		SWA25A-100	LOWER END		
-	-	-	1	1		SWA25A-110	LOWER END		
1	1	1	-	-		SWA25A-200	UPPER END SWIVEL		
-	-	-	1	1		SWA25A-210	UPPER END SWIVEL		
1	1	1	1	1		SWA10A-300	BEARING HOUSING		
1	1	1	1	1		SWA10A-400	THRUST WASHER		
1	1	1	1	1		SWA10A-500	SEMI- RINGS		
1	1	1	1	1		SWA10A-600	COLLAR		
2	2	-	-	-		SWA10A-700	WIRE CLAMP		
-	-	2	2	2		SWA10A-702A	WIRE CLAMP		
1	-	-	-	-		SWA6A-800A	CONNECTOR BUSHING		
-	1	1	-	-		SWA6A-800B	CONNECTOR BUSHING		
-	-	-	1	-		SWA6A-800C	CONNECTOR BUSHING		
1	-	-	-	-	B/O	SWA6A-900A	ROTARY CONTACT		MERCOTAC #230
-	1	-	-	-	B/O	SWA6A-900B	ROTARY CONTACT		MERCOTAC #330
-	-	1	-	-	B/O	SWA6A-900C	ROTARY CONTACT		MERCOTAC #430
-	-	-	1	-	B/O	SWA6A-900D	ROTARY CONTACT		MERCOTAC #630
-	-	-	-	1	B/O	SWA6A-900E	ROTARY CONTACT		MERCOTAC #830
1	1	1	1	1		SWA10A-1100	UPPER DU BEARING		
1	1	1	1	1	B/O	SWA10A-1200	LOWER DU BEARING		(KAMAN M8020DU)
1	1	1	1	1	B/O	SWA10A-1300	POLLER THRUST BEARING		(KAMAN B1210TN)
1	1	1	1	1	B/O	SWA10A-1400	CIRCLIP		(KAMAN N3000 350 SFF)
1	1	1	1	1		SWA10A-1800	COVER		
4	4	4	8	12	B/O	SWA6A-1900	1/4" FEMALE SPADE CONNECTOR		(MCMASTER-CARR #69525116)
-	-	4	4	4	B/O	SWA6A-2000	1/8" FEMALE SPADE CONNECTOR		(MCMASTER-CARR #69525114)
1	1	1	1	1	B/O	EL-PLUG-F	FEMALE PLUG	PE High Density	(MCMASTER-CARR #7214A6)
1	1	1	1	1	B/O	EL-PLUG-M	MALE PLUG	PE High Density	(MCMASTER-CARR #7214A5)
4	4	4	4	4	B/O	188-FFCS-1032-S/B	FLAT SOCKET CAP SCREW	S.S.	10-32 x 5/8 (MCMASTER-CARR #92210A303)
-	-	-	-	1	B/O	188-FFPS-1032-S/B	SET SCREW	S.S.	10-32 x 3/8 (MCMASTER-CARR #94355A335)
-	-	-	1	-	B/O	188-FFSS-1032-1/2	SET SCREW	S.S.	10-32 x 1/2 (MCMASTER-CARR #94355A337)
1	1	1	-	-	B/O	188-FFPS-1035-S/B	SET SCREW	S.S.	10-32 x 5/8 (MCMASTER-CARR #92311A430)
1	1	-	-	-	B/O	EL314-SJTOW	3 WIRE	6 FT.	(TRUCK & AUTO SUPPLY #EL 314-SJTOW 3/14)
-	-	1	-	-	B/O	EL14-ARTIC	4 WIRE	6 FT.	(TRUCK & AUTO SUPPLY #EL 414-ARTIC 4/14)
-	-	-	1	-	B/O	EL16-ARTIC	6 WIRE	6 FT.	(TRUCK & AUTO SUPPLY #EL 616-ARTIC)
-	-	-	-	1	B/O	EL816-ARTIC	8 WIRE	6 FT.	(TRUCK & AUTO SUPPLY #EL 816-ARTIC)
1	1	1	1	1	B/O	600.1316	UP DECAL		



1. FOR CUSTOMER REBUILD ONLY.
2. ALL ASSEMBLY TO BE DONE IN ACCORDANCE WITH SWA25A SWIVEL MANUAL.

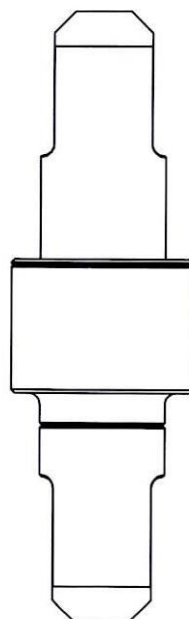
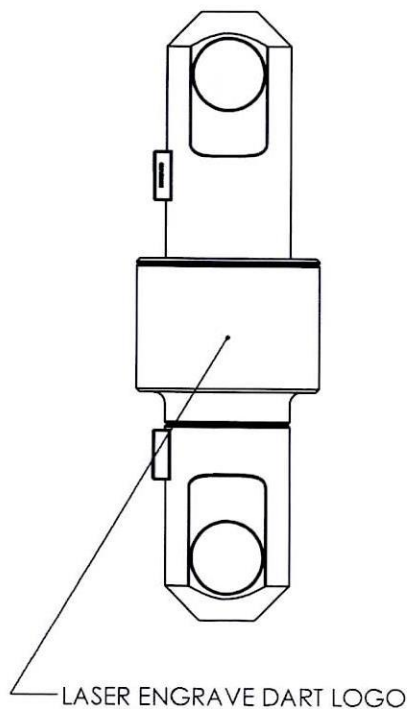
		REV 1	
TITLE		SWA25A SWIVEL	
DWG NO.		SWA25A	
MATERIAL		DRAWN BY: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS > 1/8"		APPROVED: <i>D. Ward</i> CHECKED: _____ FINISH: _____ SPEC: _____	
1. BREAK ALL SHARP EDGES .015 ± x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL: _____	
SCALE	1:4	DATE	11/14/2012
		SHEET 1 OF 2	

188-PSCS-1032-5/B)
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 123009 M

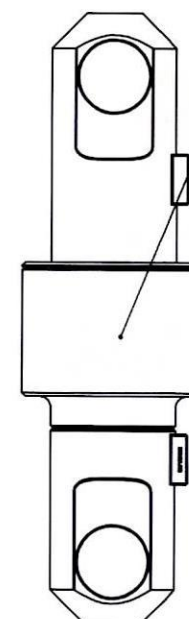
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17340

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



ENGRAVE P/N, S/N, SWL



DART AEROSPACE	
TITLE SWA25A SWIVEL	
DWG NO. SWA25A	REV 1
MAT'L	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005	HEAT
.XX ± .01	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:4	DATE 11/14/2012 SHEET 2 OF 2

Work Order SWA25A-3

Customer _____

Number of Wires 3

Date 18/03/16

Serial Number S047209

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	25,000	Check for Conductivity against all wires.	- Pass
1	25,000	Check all wires for grounding against swivel body.	- Pass
1	12,500	Check for Conductivity against all wires.	- Pass
1	12,500	Check all wires for grounding against swivel body.	- Pass
1	6,250	Check for Conductivity against all wires.	- Pass
1	6,250	Check all wires for grounding against swivel body.	- Pass
1	0	Check for Conductivity against all wires.	- Pass
1	0	Check all wires for grounding against swivel body.	- Pass

Test Conducted By: Emilie Boucher

Technician

Signature: [Signature]
QC 5 Small FAB / QA

Submit